

Date: Tuesday, 10/2/2007 3:53:12 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS
Job Number : 34995	
Estimate Number : 10574	
P.O. Number : N/A	Part Number : D34531
This Issue : 10/2/2007 S.O. No. :	Drawing Number : D3453 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11	Drawing Revision : A
Previous Run : 34942	Material : N/A
Written By : <i>[Signature]</i> 67-10-02	Due Date : 10/9/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 24 Um: Each
Comment : A 05.09.27 New issue EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304R1250-1500 *[Signature]* Inventory



Comment: Qty.: 0.2880 f(s)/Unit Total : 6.9120 f(s)

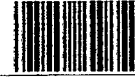
Material: AISI 304 SS Round Bar Ø1.250

(M304R1.250)

Batch: *M10549*

278' M103154

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA577 Rev: *A* & Dwg D3453 Rev: *A*

2- Deburr as per dwg D3453

20 07/10/03 *DSP 07/10/04*
INSPECT PARTS AS THEY COME OFF MACHINE

3.0 QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 07/10/03 *DSP 07/10/04*

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Mill as per Folio FA577 Rev: *A* & Dwg D3453 Rev: *A*

2- Deburr as per dwg 3453

mk 07/11/11

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 07/11/11

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

2F 07/11/13

23

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2F 07/11/13

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SL 07/11/13

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST. 95

AS

07/11/13

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2F 07/11/14

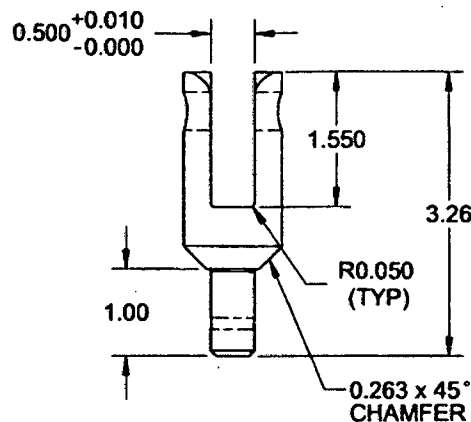
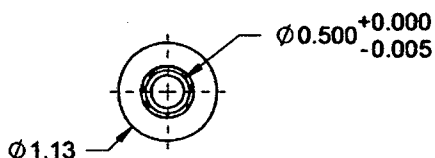
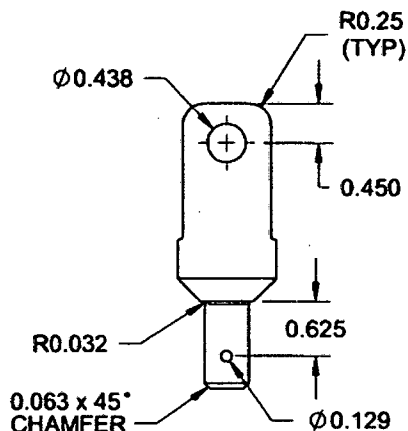
Job Completion



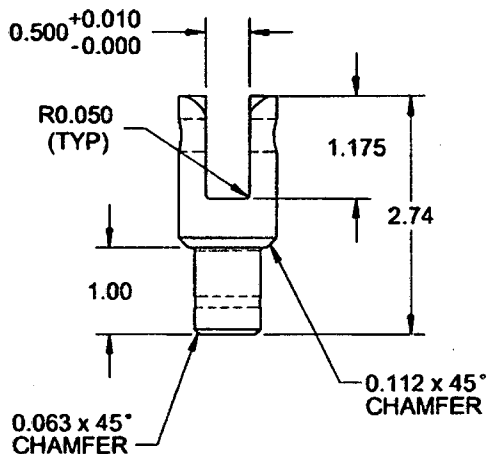
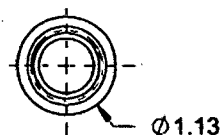
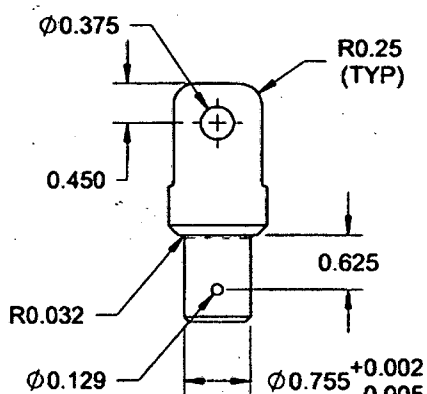
W 07.11.13

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3453	REV. A SHEET 1 OF 2
DATE 05.09.02		TITLE CLEVIS	SCALE 1:2
A	05.09.02	NEW ISSUE	

**D3453-1 CLEVIS****RELEASED**

05.12.09 [Signature]

**D3453-3 CLEVIS****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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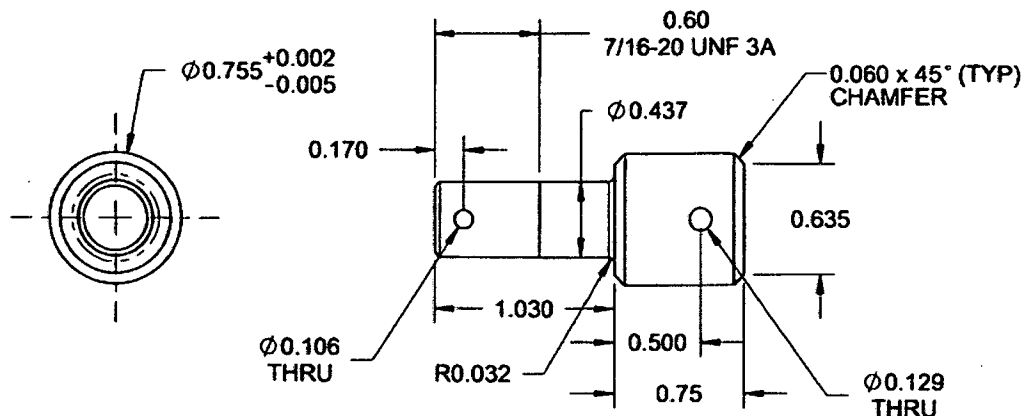
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3453	REV. A SHEET 2 OF 2
DATE 05.09.02		TITLE CLEVIS	SCALE 1:1

RELEASED

05.12.09 #

**D3453-5 PLUG****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

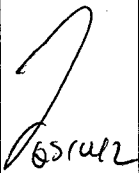
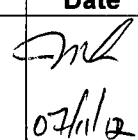
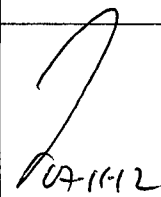

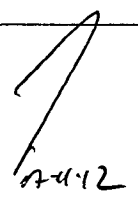
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/11	4.0	1 piece scrap I turn to muck the 4 th axis. and mill in the wrong place operator error		Scrap destroyed	 07/11/12	 07/11/12	 07/11/12	 07/11/12

NOTE: Date & initial all entries

